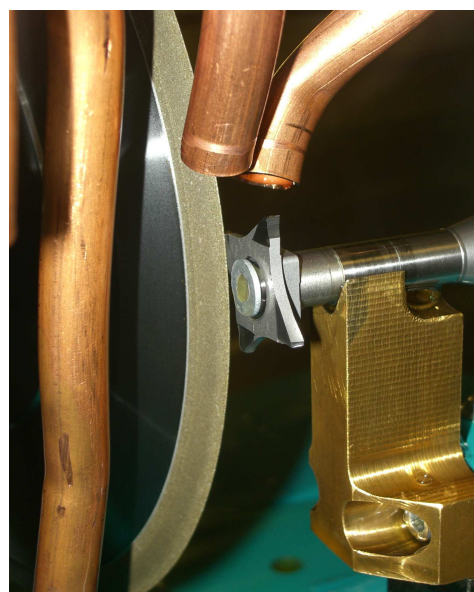
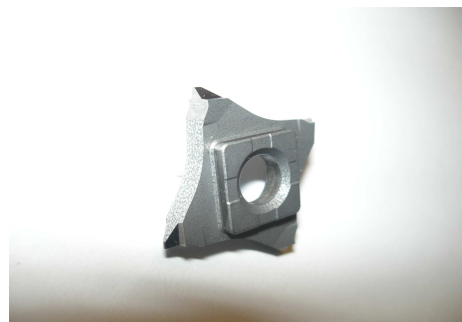









## Grooving Insert Z4

### A08-350

Grooving Inserts chucked through TTC are ground profiled inserts on edge. The advantage of TTC clamping: all operations to accomplish a finished tool are executed in one setup. The accessibility of all 4 cutting edges makes indexing as simple as just rotating the A-Axis.



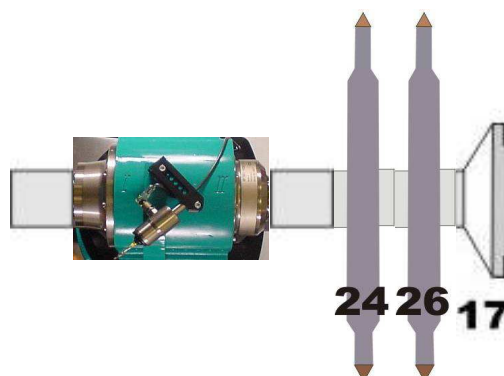
### 1. Cycletime for Production

Tool specifications BxSxS: 2.0x25x25 Material CARBIDE				
Operations				
Feed [mm/Min]	2000	50	45	80
Power [kW]		4	1	1
Cutting feed [m/s]		22	24	24
Used wheels				
Grinding time [s]	8	51	147	135
Total cycle time	5 Min 41			

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

17 Ø125 12A2 D64  
26 Ø300 14V1 D46  
24 Ø300 14V1 D64



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIR HPM, STL 650  
Control: Fanuc 160i  
Coolant: Synthetic Oil, pressure 6 - 7 bar  
Software: Quinto 4.3

responsible engineer: OP,19.11.07

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